

Date: Monday, 15/12/2008 3:14:07 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TAIL LIGHT FAIRING
Job Number : 44096 - 2
Estimate Number : 12418
P.O. Number :
This Issue : 15/12/2008 S.O. No. :
Prsht Rev. : NC Part Number : D3484042
First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3484 REV E
Previous Run : 43277 Project Number : N/A
Drawing Revision : E
Material :
Due Date : 22/12/2008 Qty: 3 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev A New Issue 06-05-23 EC
Est Rev B 08-01-24 change rivet for CR1122-3-025 DD
verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D34842

Base, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

BASE, RH

Batch: 334457-1

SP 08.12.18

2.0

D34844

Face, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

FACE, RH

Batch: 343252

3.0

D34846

Cone, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

CONE, RH

Batch: 336403

SP 08.12.18

4.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig

A/R AL ROD Batch: M 104855

2-Buff & Smooth Welds to mating surfaces

SP 08.12.

Date: Monday, 15/12/2008 3:14:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44096

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

CR1122 3 025

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch: _____

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

ANCHOR NUT

Batch: _____

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Date: Monday, 15/12/2008 3:14:08 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44096

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA,DART AEROSPACE LTD

P/N:D412-750-142 B/N:BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

QC21

FINAL INSPECTION/W/O RELEASE

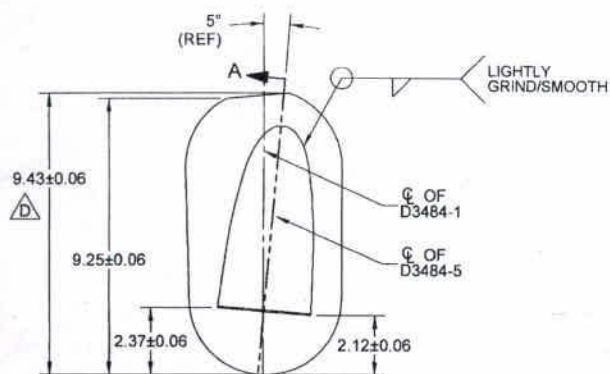


Comment: FINAL INSPECTION/W/O RELEASE

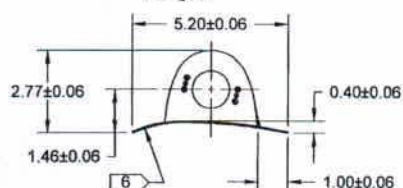
Job Completion



h 09.01.10

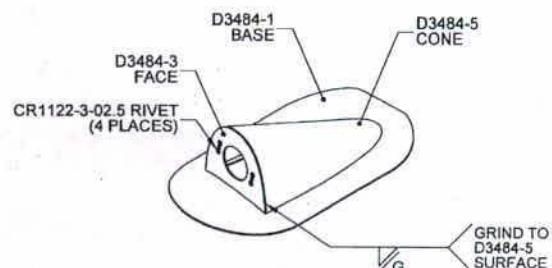


QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
		D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



SECTION A-A

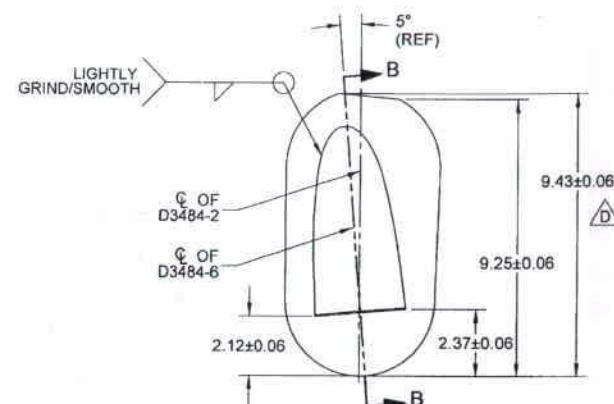
D3484-041 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW

NOTES:

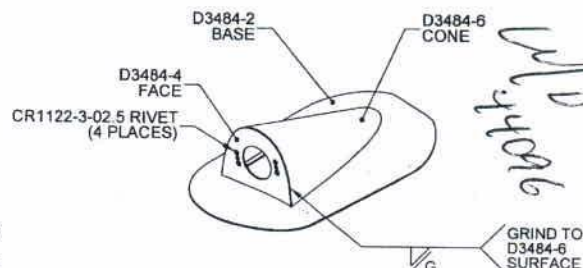
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs



INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION B-B

D3484-042 TAIL LIGHT FAIRING



D3484-042 ISOMETRIC VIEW

E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.03		

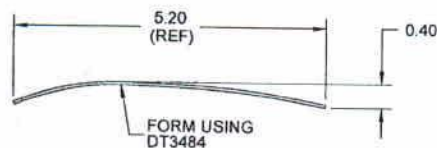
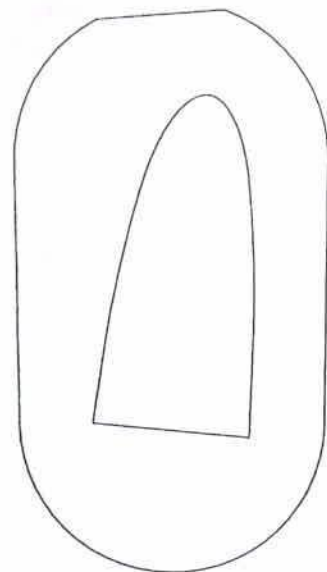
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3484

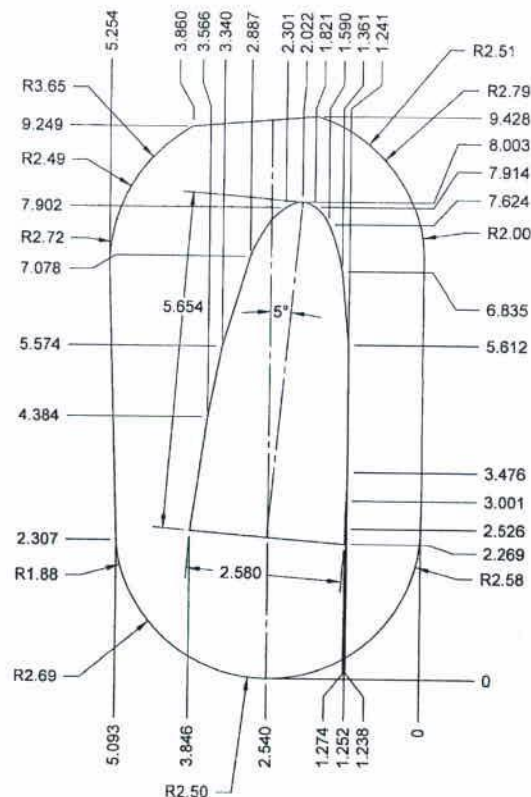
TITLE
TAIL LIGHT FAIRING

REV. E
SHEET 1 OF 4
SCALE
1:4

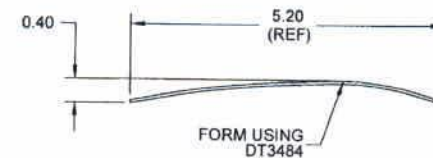
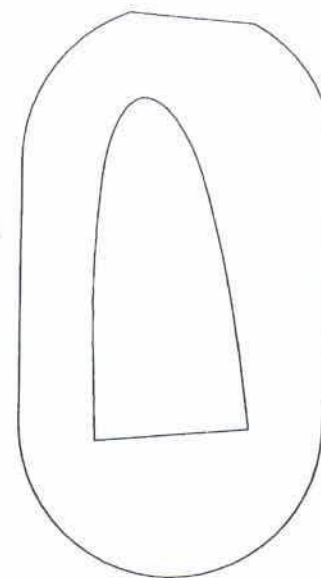
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D3484-1 BASE
(MAKE FROM D3484-1F)



D3484-1F BASE FLAT PATTERN



D3484-2 BASE
(MAKE FROM D3484-1F)

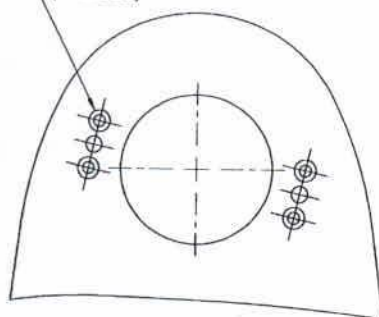
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S 050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

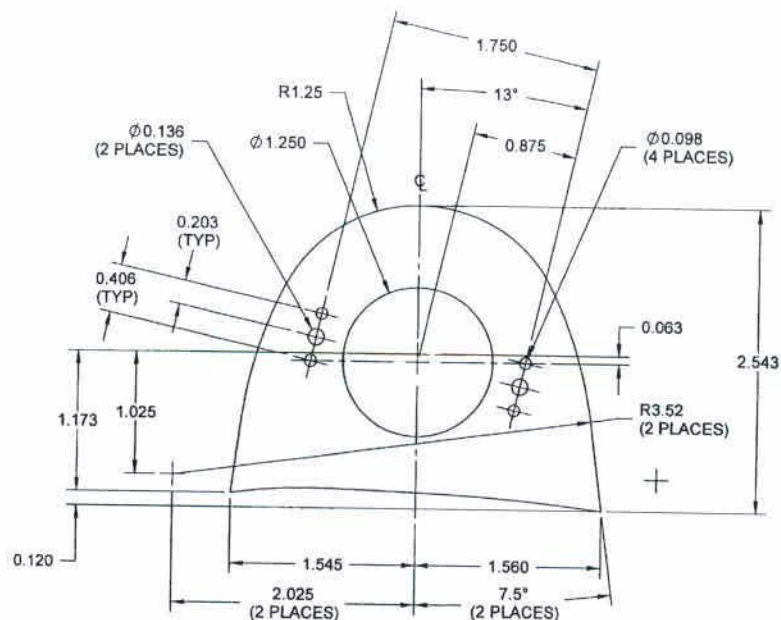
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3484
MFG. APPR.		REV. E
APPROVED		SHEET 2 OF 4
DE APPR.		TITLE TAIL LIGHT FAIRING
DATE	08.01.03	SCALE 1:2

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C'SINK
Ø0.181 X 100°
(4 PLACES)

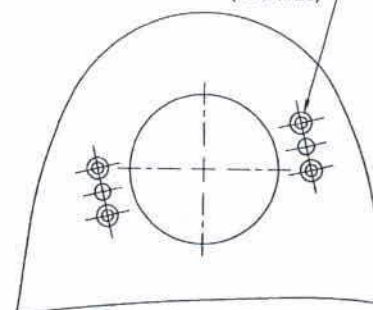


D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

C'SINK
Ø0.181 X 100°
(4 PLACES)



D3484-4 FACE
(MAKE FROM D3484-3F)

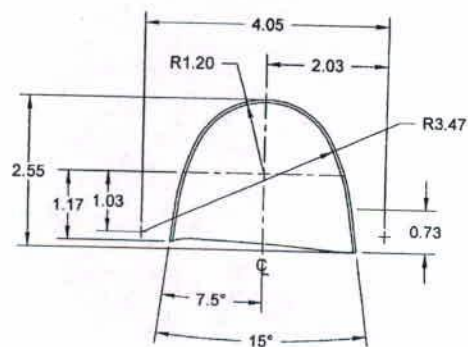
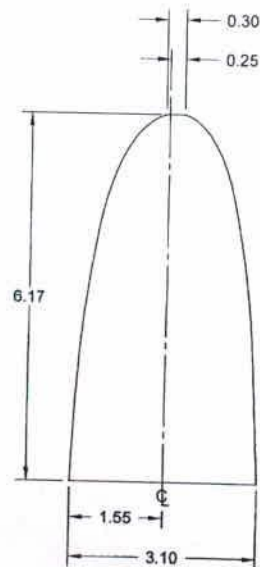
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

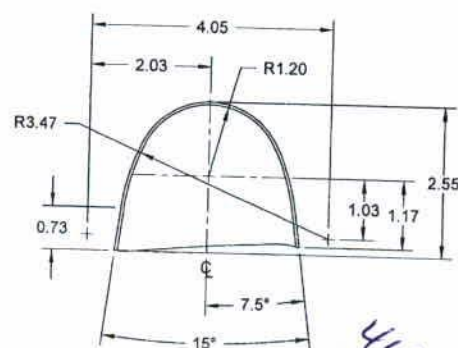
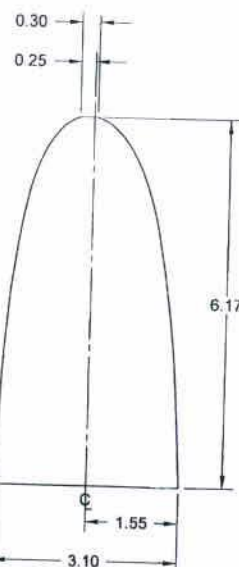
44096

RELEASED
08-01-17

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3484	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:1
DATE	08.01.03	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

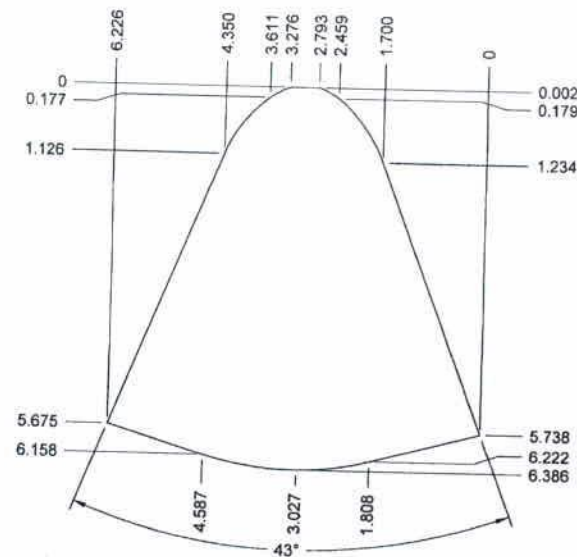


D3484-5 CONE
(MAKE FROM D3484-5F)



D3484-6 CONE
(MAKE FROM D3484-5F)

44096



D3484-5F CONE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

11 08.01.17

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3484
MFG. APPR.		REV. E
APPROVED		SHEET 4 OF 4
DE APPR.		TITLE TAIL LIGHT FAIRING
DATE	08.01.03	SCALE 1:2

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